

YAWATA 71T-1

For Mild Steel and 490 N/mm² High Tensile Strength Steel

Classification

AWS A 5.20 : E71T-1C
AWS A 5.36 : E71T1-C1A0-CS1-H8

Approvals

ABS, LR

Applications

All position welding of mild and medium strength steel for machinery, structures, ships, bridges, towers, chemical engineering apparatus or storage tank.

Characteristics

YAWATA 71T-1 is a flux cored arc welding wire to be used with CO₂ shield gas. Smooth running, very low spatter, easily removable slag and excellent X-ray quality. Recommended for high speed fillet and butt welding of mild and medium strength steel.

Typical Chemical Composition of Deposited Metal (%)

Shield Gas	C	Si	Mn	P	S
CO ₂	0.05	0.51	1.26	0.010	0.008

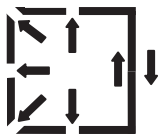
Typical Mechanical Properties of Deposited Metal

Tensile Strength N/mm ²	Yield Strength N/mm ²	Elongation %	Charpy 2V-notch J (kgf.m)
570	510	29	-18°C 100 (9.8)

Sizes & Recommended Current Range (DC +)

Diameter (mm)	1.2	1.4	1.6
Welding Position	Current (A)		
F, HF	120~300	150~400	180~450
H	120~280	150~320	180~350
VD	200~260	220~270	230~280

Welding Positions



All positions